



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1915

Job Sheet 181391



Part No: 647.1915

Job Qty: 30 ea

Part Name: Support Angle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C SHEETS 1,2,3,7 IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Machining-1		52 18/08/19
100	Bandsaw	30 pcs	9/10/18	9/10/18	0.00	1.20	Bandsaw1		9-89 18/08/19
110	CNC Vertical Machining	30 pcs	9/10/18	9/10/18	0.00	23.94	HAAS1-1		18/08/19
120	QC	30 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Machining-1		18/08/19
130	QC	30 pcs	9/10/18	9/10/18	0.00	0.00	QC8 Machining-1		18-08-21
140	Outsource	30 pcs	9/10/18	9/10/18			ATG001-VC		18-08-21
150	Packaging	30 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2		18-08-21
155	QC	30 pcs	9/10/18	9/10/18	0.00	0.00	QC5		18-08-21
180	Packaging	30 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		18-08-21
190	QC21-SA	30 Ea	9/10/18	9/10/18	0.00	0.00	QC21		18-08-21

Part Op 100 - Cut Blanks at 14.625"

Descriptions: 110 - 1-Machine per folio FB286 DWG REV: _____ FOLIO REV: _____ 2- deburr and break all sharp edges
140 - Issue P/O to ATG : 1- Black Anodize as per Dwg 647.1900 2- PRIME AS PER DWG, SEE NOTE #2
Certification of Conformity is required
180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.1915E	Support Angle	37.5000 Ea (1.25 ea) 1.47 ea	90-Start up Operation	391666 5100786

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	647.1915E	38	209	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support Angle	14.500Inches ± 0.010	14.510 14.490	14.500"	
2	Support Angle	0.360Inches ± 0.005	0.365 0.355	0.358"	
3	Support Angle	2.250Inches ± 0.002	2.252 2.248	2.250"	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order Part NCR Date : 	Part: 647.1915 Job No: 181391 Serial No/Batch: S100793 Revision: Inspector: Exp Date: Instructions: Container No: S100793 DART Aerospace 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 08/09/18	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;"> AGAINST DEPARTMENT/PROCESS ss tube ☐ nall Fab ☐ inishing ☐ nposite ☐ </td> <td style="width: 30%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 40%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> <tr> <td colspan="2"> Disposition </td> <td> MRB (QSI042) Approval </td> </tr> <tr> <td colspan="2"> Completed By </td> <td> Lead hand / Supervisor Approval Verification </td> </tr> <tr> <td colspan="2"> QC / QA Coordinator Approval </td> <td> </td> </tr> </table>	AGAINST DEPARTMENT/PROCESS ss tube ☐ nall Fab ☐ inishing ☐ nposite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐	Disposition		MRB (QSI042) Approval	Completed By		Lead hand / Supervisor Approval Verification	QC / QA Coordinator Approval		
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Disposition		MRB (QSI042) Approval												
Completed By		Lead hand / Supervisor Approval Verification												
QC / QA Coordinator Approval														

Root Cause	FAULT CATEGORY				
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OTHER : ☐					

4	Support Angle	0.201Inches + 0.005 - 0.001	0.206 0.200	0.202" Diameter
5	Support Angle	6.125Inches ± 0.005	6.130 6.120	6.125"
6	Support Angle	0.250Inches ± 0.010	0.260 0.240	0.250"
7	Support Angle	45.000Degrees ± 0.500	45.500 44.500	45° Angle

JJP
18-08-08

Plex 7/26/18 8:01 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040777**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040777

PO Date: 8/20/18

Due Date: 9/7/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, Chrisoula

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items												
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
1	181419	647.7912	Clip ISSUE P/O: Hard Anodize, Color Black and Prime As Per Dwg. 647.7900	Firmed	-	9/7/18	100 pcs	0 pcs	100 pcs	\$9.35/pcs	\$935.00	
2	181352	647.1914	Bracket Issue P/O to ATG : 1- Black Anodize as per Dwg 647.1900	Firmed	-	9/7/18	40 pcs	0 pcs	40 pcs	\$9.15/pcs	\$366.00	
3	181391	647.1915	Support Angle Issue P/O to ATG : 1- Black Anodize as per Dwg 647.1900 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	Firmed	-	9/7/18	30 pcs	0 pcs	30 pcs	\$11.45/pcs	\$343.50	
4	181389	647.1913	Tee Issue P/O to ATG : 1- Black Anodize as per Dwg 647.1900 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	Firmed	-	9/7/18	45 pcs	0 pcs	45 pcs	\$11.45/pcs	\$515.25	

30x AUG 31 2018

CT

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	178869	C10-1	Side Plate Solenoid Side -Issue P/O to ATG : -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	8/27/18	4 pcs	0 pcs	4 pcs	\$16.40/pcs	\$65.60
4 X AUG 24 2018											
Line Item Note **big, big rush**											
6	178871	C10-2	Side Plate - MRK -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	8/27/18	4 pcs	0 pcs	4 pcs	\$16.40/pcs	\$65.60
4 X AUG 24 2018											
Line Item Note **Big, big rush **											
7	181358	647.1811	Spacer ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	-	9/7/18	50 pcs	0 pcs	50 pcs	\$6.90/pcs	\$345.00
50 X AUG 31 2018											
Grand Total:											\$2,635.95

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/23/18 9:51 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915896

Date: 30-Aug-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chris Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
30 ea	Part: 647.1915 Support Angle Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23617	Rev: NC	Line: 3
50 ea	Part: 647.1811 Spacer Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23621	Rev: A	Line: 7
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>30/8/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			